

Date: Thursday, 29/05/2008 3:17:36 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT ASSEMBLY	
Job Number :	39583	Part Number :	D23241	
Estimate Number :	10732	Drawing Number :	D2324 REV. C	
P.O. Number :		Project Number :	N/A	
This Issue :	29/05/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	C	
First Issue :	/ /	Type :	SMALL /MED FAB	
Previous Run :	39152	Material :		
Written By :		Due Date :	06/06/2008	Qty: 20 Um: Each
Checked & Approved By :	<u>JYD 08.5.29</u>			
Comment :	Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	39583A	STOP
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Comment: Sub-Component STOP

D2324-3 B 39152A

EJ 08/05/30

2.0	39583B	STRAP
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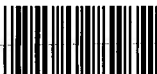


Comment: Sub-Component STRAP

D2324-5 B 39152B

EJ 08/05/30

3.0	AN312A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt M106605

EJ 08/05/30

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer M108077

EJ 08/05/30

5.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut M107644

EJ 08/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 3:17:36 PM
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Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2324.

08/05/30 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



SAW no scratches.



Comment: INSPECT WORK TO CURRENT STEP

08/05/30 (420)

8.0

POWDER COATING

POWDER COATING



m107925



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 12:50
OVEN TEMPERATURE: 320°
FINISH TIME: 1:20

FX 08/06/02 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08-06-02 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

SPD 3 PC 08/06/02 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion



08/06/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

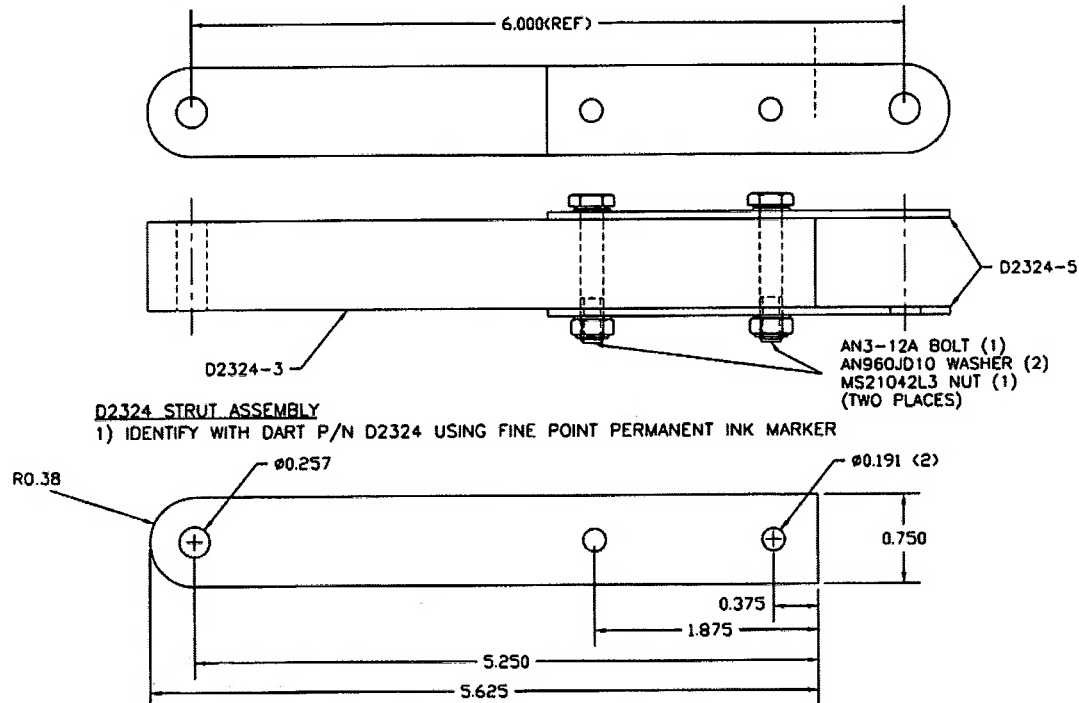
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

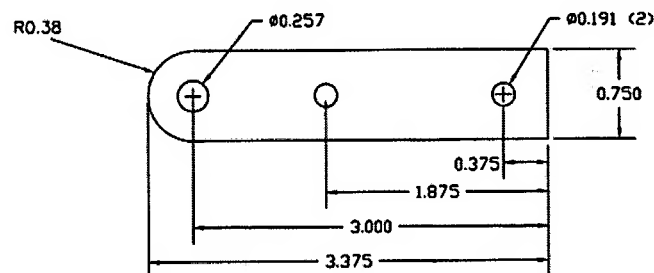
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT		SCALE
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39583

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries